

# Work Order ID 52913

October 19, 2009 12:45:52 PM



Page 1

Item ID: D3276-3

Accept



Setup Start



Revision ID: B

Item Name: Decal

Stop



Start Date: 10/19/09 Start Qty: 4.00



Cust Item ID:

Required Date: 11/02/09 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: *PP*

Date: *09-10-19*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3276

Rev B

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: *10600* ☐ For D3276-3 decal as per Dwg D3276 ☐ Possible  
Supplier: Studio Lettrage ☐ Material release note is required

*CY 09/10/20 10*

110

0.00



Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

*Pcs/w/21 (10)*

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

*=> 805/10/22*

*(10) f*

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October 19, 2009 12:45:52 PM

Page 2

Item ID: D3276-3

Accept

Revision ID: B

Item Name: Decal

Start Date: 10/19/09 Start Qty: 4.00

Required Date: 11/02/09 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: 7B

0.00

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09.10.27  
MF  
09-10-23

# Picklist Print

October 19, 2009 12:45:56 PM

Page 1

Work Order ID: 52913

Parent Item: D3276-3RevB

Parent Item Name: Decal



Comments:

Start Date: 10/19/09

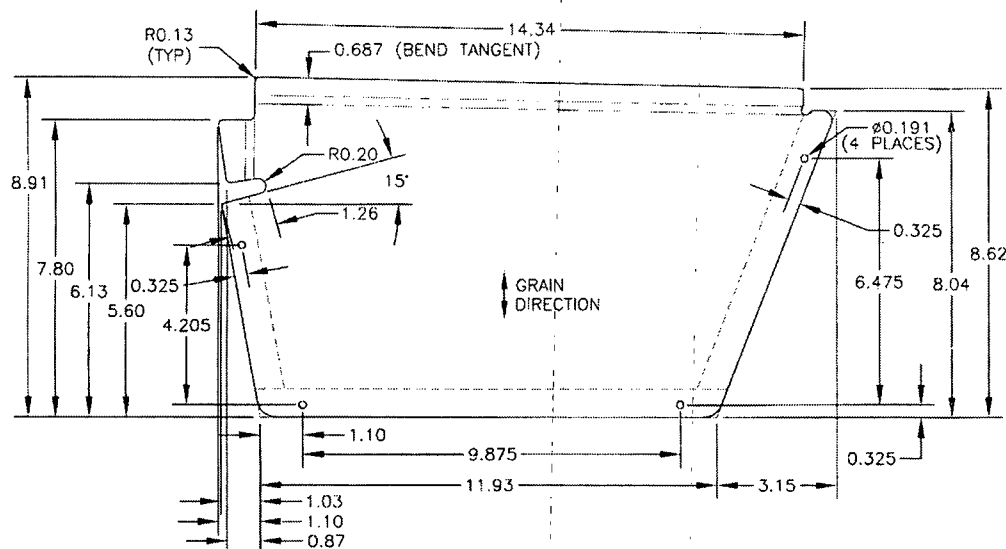
Required Date: 11/02/09

Start Qty: 4.00

Required Qty: 4.00

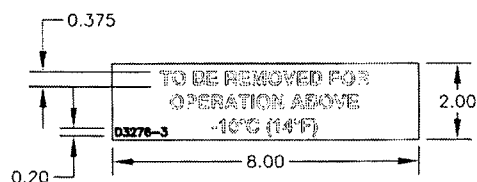
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3276-3PRevB		Purchased	No			100	Each	0.0000	4.0000			
												
Decal												

*10/19/09 21 (10)*



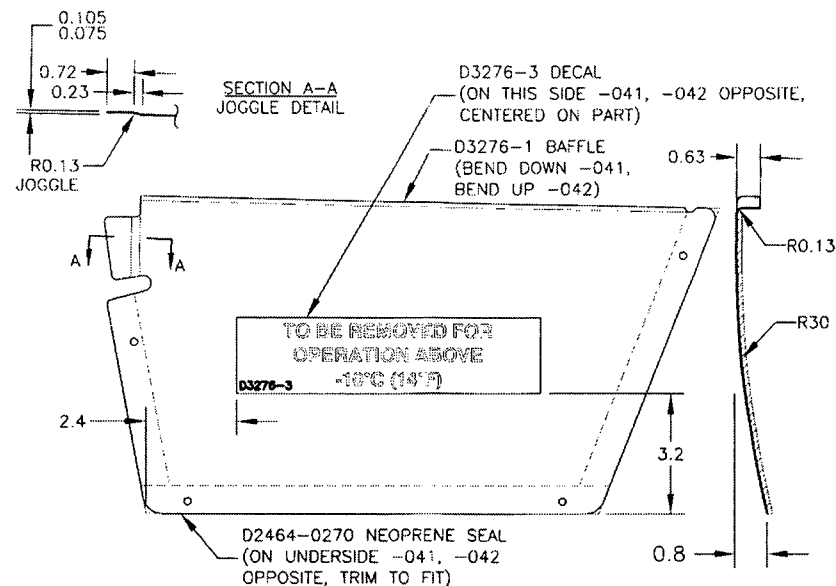
#### D3276-1 BAFFLE (FLAT PATTERN)

- 1) MACHINE PER DWG FILE "D3276-A.DWG"
- 2) MATERIAL: 6061-T6 ALUMINUM 0.040 THICK (QQ-A-250/11)  
(REF DART SPEC. M6061T6S.040)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



#### D3276-3 DECAL

- 1) RED LETTERING ON WHITE ADHESIVE BACK
- 2) MANUFACTURE FROM 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



#### D3276-041 BAFFLE ASSEMBLY, LH (SHOWN) D3276-042 BAFFLE ASSEMBLY, RH (BEND/JOGGLE OPPOSITE)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 52913  
PL 09-10-19

RELEASED  
05/02/02

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PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE LTD.

B	05.01.25	LABEL NOW -10°C: CURVE PART
A	05.01.07	NEW ISSUE
DESIGN	CP	DRAWN BY CP
CHECKED	✓	APPROVED
DATE	05.01.25	TITLE
		BAFFLE ASSEMBLY
		DART AEROSPACE LTD. WARRICKSURY, OXFORD, ENGLAND
		DRAWING NO. D3276
		REV. B
		SHEET 1 OF 1
		SCALE 1:3



210 MAIN W.,  
HAWKESBURY, ONT. K6A 2H6

Tel.: 613 632-2001

Fax: 613 632-9491

www.studiolettrage.com

# INVOICE / FACTURE

VENDU À:  
SOLD TO:

Dart Aerospace Ltd  
1270 Aberdeen  
Hawkesbury, Ontario K6A 1K7

LIVRÉ À:  
SHIPPED TO:

Dart Aerospace Ltd  
Hawkesbury, Ontario

No.:

12936

DATE:

10/21/2009

PAGE

1 of 1

Re: Quote No. 7814

ITEM ARTICLE	QTY QYE	UNIT UNITÉ	DESCRIPTION	GST TPS	PST TVP	UNIT PRICE PRIX UNITÉ	AMT MON
	10		D3276-3P set up	E		5.00	50
	20		D2269P set up	E		2.50	50
	1		Printing	E		75.00	75
			E - GST @ 5%				
			GST				
			PST Exempt: #6122-5207				
Studio de Lettrage GST: #869034678RP001							
PO 10600							
Sold By:							
TOTAL							180

Merci! Thank You!



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO10600**

Purchase Order Date 10/20/09

PO Print Date 10/20/09

Page Number 1 of 1

**Order From :**

VC-STU001

STUDIO DE LETTRAGE 2001  
210 MAIN WEST  
HAWKESBURY, ON K6A 2H6  
CA

**FAXED**  
613 632 1053

**Contact Name**

**Vendor Phone**

613 632 5449

**Vendor Fax**

613 632 9491

**Vendor Account Nbr**

**Buyer**

Chantal Lavoie

**Requisition Nbr**

**Tax Resale Nbr**

10127-2607

**Terms**

Net 30

**Currency**

CAD

**FOB**

**Ship To :**

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3276-3P B	Decal	10/23/09 Yes	10.00 Each	Yours ppd	\$5.7700	\$57.70
			<b>Special Inst:</b> AS PER DWG D3276 REV. B B52913				
2	D2269P B1	Placard	10/23/09 Yes	20.00 Each	Yours ppd	\$5.0000	\$100.00

**Special Inst:** AS PER DWG D2269 REV. B1  
B52916

**PO Total:**

**\$157.70**

**CERTIFICATE OF CONFORMITY  
REQ'D UPON DELIVERY**

Change Nbr:

1

Change Date: 10/20/09

*u* *CL*  
No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable



# Scotchcal™

## Opaque Imaging Media 8522

### Description

This media is specially formulated to dry quickly after printing. Production of outdoor weatherable and long-term indoor durable graphics is now easier than ever. Its changeable adhesive allows easy removal for up to one year.

### Advantages

- Optimized for use with selected Epson Stylus Pro printers and Epson Archival inks.
- Optimized for use with selected HP DesignJet Printers and HP DesignJet Ink System UV or HP83UV Color Ink System
- For making opaque, laminated graphics that are outdoor weatherable and long-term indoor durable
- Media:
  - For opaque (reflective) graphics
  - Changeable, easy to remove from warranted substrates up to 1 year later
  - Dries quickly after printing so the overlamine can be applied almost immediately
  - Low slippage paper liner for superior tiling
- Overlaminates:
  - Provide additional UV (ultraviolet) and physical protection for making weatherable finished graphics
  - Available in luster and matte gloss
  - Adhesive allows for heat-assisted or cold-temperature lamination

### Applications and Uses

3M™ Scotchcal™ Changeable Opaque Imaging Media 8522 is intended only for ink jet printing and for use with the listed Compatible Products and Equipment and the following applications. Any other application is NOT warranted by 3M or covered by the worldwide 3M™ MCS™ Warranty unless 3M gives its prior written approval for the application.

- First surface images (the image is on top of the film) for opaque posters and signs, including:
  - Graphics for vans, personal vehicles, trucks and buses
  - Novelty posters
  - Retail and point-of-purchase displays
  - Information graphics such as maps and directories
  - Entertainment promotions in museums, zoos, parks, theatres, sports venues
  - Education and presentation graphics

02/10/30

### Product Bulletin 8522

Release F, Effective January 2003  
Black bar in margin indicates a change

- Legal and courtroom exhibits
- For flat or simple curved surfaces, with or without rivets, used in vertical ( $\pm 10^\circ$ ) applications

### Limitations of End Uses

The following uses and applications are specifically NOT warranted.

- Fleet applications in areas that use salt for winter road maintenance
- Application to non-warranted substrates, including wall-board
- Applications subjected to gasoline vapors or spills
- Application to corrugated or highly irregular surfaces or sharply raised areas
- Graphics applied to stainless steel, including stainless steel vehicles
- On flat surfaces with rivets, tenting of 4 to 10 mm around rivets may be expected; rivets may be cut around to eliminate tenting.

Note: Standard ink jet technology is water based. Water-based chemistry is susceptible to the extremes of heat and humidity. This is a factor in most product constructions on the market. Read the Fabrication, Shelf Life and Storage sections in this bulletin. Staying in the middle of these ranges always provides optimum performance.

### Compatible Products and Equipment

#### Thermal Ink Jet Printing Systems

- Epson Stylus Pro 9500, Stylus Pro 10000 printer
  - Epson Archival Inks
- Epson Stylus Pro 10600 printer
  - Epson Archival Inks
- HP DesignJet Printers 2000 and 3000 series
  - HP DesignJet Ink System UV (pigment-based ink)
- HP DesignJet Printers 5000 series
  - HP83UV Color Ink System

#### Overlaminates (required)


- 3M™ Luster Overlamine 8519 (semi-gloss)
- 3M™ Matte Overlamine 8520

Note: For the full product names of the 3M products listed on this page, please see page 1.

## Shelf Life and Storage

- 3M™ Scotchcal™ Changeable Opaque Imaging Media 8522 has a shelf life of one year.
- Storage conditions (new and partially used rolls). For optimum performance, use the middle of these ranges:
  - Original packaging, including plastic wrap
  - Relative humidity of 20% to 80%
  - Temperature of 33° to 104°F (0° to 40°C)
  - Away from direct sunlight
- Do not stack unprotected rolls or lay sharp or heavy objects on them.

## Health and Safety

 **Caution**

When handling any chemical products, read the manufacturers' container labels and the Material Safety Data Sheets (MSDS) for important health, safety and environmental information.

To obtain MSDS sheets for 3M products:

- By fax, call 1-800-364-0768 in the US and Canada or 1-650-556-8417 for all other locations.
- Electronically, visit us at <http://www.3M.com/msds>.
- By mail, or in case of an emergency, call 1-800-364-3577 or 1-651-737-6501.

When using any equipment, always follow the manufacturers' instructions for safe operation.

## Warranty and Limited Remedies

### 3M™ MCS™ Warranty for Graphics Produced on HP DesignJet Printers and Epson Stylus Pro Printers

*The following is made in lieu of all other express or implied warranties, including any implied warranty of merchantability or fitness for a particular purpose:* We warrant graphics produced by a 3M Ink Jet Registered Fabricator made with imaging media 8522, printed on an approved HP thermal ink jet printer according to HP's recommendations or Epson Stylus Pro printer according to Epson's recommendations, overlaminated with 8519 or 8520, and applied to a Warranted Substrate according to 3M's recommendations. These



#### Commercial Graphics Division

3M Center, Building 220-6W-06  
PO Box 33220  
St. Paul, MN 55133-3220 USA  
General Info. 1-800-374-6772  
Technical Info. 1-800-328-3908  
Fax 1-651-736-4233

Fax-on-Demand 1-800-364-0768 US/Canada or 1-651-732-6506 International  
Fax-on-Demand document: 4506  
[www.scotchprint.com](http://www.scotchprint.com)

#### 3M Canada

P.O. Box 5757  
London, Ontario  
Canada N6A 4T1  
1-800-265-1840  
Fax 519-452-6245

#### 3M México, S.A. de C.V.

Av. Santa Fe No. 55  
Col. Santa Fe. Del. Alvaro Obregón  
México, D.F. 01210  
52-55-52-70-04-00  
Fax 52-55-52-70-22-77

#### 3M Puerto Rico, Inc.

Puerto Rico Industrial Park  
P.O. Box 100  
Carolina, PR 00986-0100  
787-620-3000  
Fax 787-750-3035

graphics are covered against failure caused by ultraviolet light, temperature extremes, pollution, and other elements.

If a graphic fails to perform in accordance with 3M product specifications within this time frame, 3M will replace the materials at no charge. **These remedies are exclusive. In no case shall 3M be liable for any direct, indirect, or consequential damages, including any labor charges.**

## 3M Related Literature

Listed below is related 3M technical literature that may be of interest. You may view and print these Bulletins from our Web site at [www.scotchprint.com](http://www.scotchprint.com), or order them via our Fax-on-Demand (FOD) system. Call one of these phone numbers to order the desired bulletins, and specify the FOD document number provided in the chart.

United States or Canada: 1-800-364-0768

International: 1-651-732-6506

Subject	Bulletin No.	FOD No.
<b>Product Bulletins</b>		
3M™ Scotchcal™ Overlamine 8519 and 8520	8519/8520	4524
<b>Instruction Bulletins</b>		
Making thermal ink jet graphics	4.23	6523
Application, substrate selection, preparation and substrate-specific application techniques	5.1	7001
<b>Warranties</b>		
Worldwide 3M™ MCS™ Warranty Packet (includes all Commercial Graphics MCS Warranties)		9503
Worldwide 3M™ MCS™ Warranty Overview-Folder		9504

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HP and DesignJet are trademarks of Hewlett Packard.

Sintra is a trademark of Swiss Aluminum Ltd.

Imron is a registered trademark of DuPont in the United States

## Bulletin Change Summary

The Epson Stylus Pro Printers 9500, 10000 10600, and Epson Archival Inks have been added to this bulletin. Additional changes resulting from this addition are marked with black bars in the margin.




Note: For the full product names of the 3M products listed on this page, please see page 1.

## Shelf Life and Storage

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52-55-52-70-04-00  
Fax 52-55-52-70-22-77

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